

**WHAT IS CLAIMED IS:**

1. A shrinkage-free sealing structure of a heat pipe, comprising a double-layered structure formed by transversely pressing a first side of an open end of the heat pipe towards a second side of the open end for at least once and  
5 transversely pressing the second side towards the first side for at least once.
2. The sealing structure of Claim 1, wherein the double-layered structure has an arrowhead cross section.
3. The sealing structure of Claim 1, wherein the double-layered structure has a narrow slit therein.
- 10 4. The sealing structure of Claim 3, further comprising a covering portion sealing the narrow slit.
5. The sealing structure of Claim 4, wherein the covering portion is formed by brazing, soldering or welding.
6. The sealing structure of Claim 1, wherein the double-layered  
15 structure has a W-shape cross section.
7. A method of forming a sealing structure at an open end of a heat pipe, comprising:
  - a) pressing one side of the open end towards the other side of the open end to form a double-layered structure with one concave side and one convex side;
  - 20 and
  - b) pressing the convex side towards the concave side to form the sealing structure.
8. The method of Claim 7, wherein step (a) further comprises using a mold having a concave contact and a mold having a convex contact to press the  
25 open end.
9. The method of Claim 8, wherein step (b) further comprises using a mold having a recessed triangular contact is placed at the concave side and a

mold having a protruding triangular contact is placed at the convex side for pressing the double-layer structure.

10. The method of Claim 7, further comprising the step of forming a covering portion to cover the sealing structure.

5 11. The method of Claim 10, wherein the covering portion is formed by brazing, soldering or welding.

12. The method of Claim 7, further comprising the step of pressing two opposing sides of the sealing structure against each other after step (b).

13. The method of Claim 7, wherein step (a) further comprises pressing  
10 the open end into the double-layered structure having a semi-circular cross section.

14. The method of Claim 13, wherein step (b) further comprises pressing the open end into the double-layered structure having an arrowhead cross section.

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